Date:

Wednesday, 3/14/2007 3:32:49 PM

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 31231

Estimate Number

: 10008

P.O. Number

:H/A

This Issue Prsht Rev. : 3/14/2007

: NC

: 30056

: 3/14/2007

Type

: MACHINED PARTS

Part Number

: D2591

Drawing Number

Drawing Name

Project Number

. D2591 REV D : N/A

: LUG

Drawing Revision

Material **Due Date** : NA : 3/27/2007

Qty:

60 Um:

Each

Written By

First Issue

Previous Run

Checked & Approved By Comment

: Est Rev: I Removed from 9 Digit 05-10-25 JLM

S.O. No. : HA

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

M1010B0750X02500

ASTM A21 Steel .75"x2.5"



Comment: Qty.:

0.2340 f(s)/Unit Total: 14.0400 f(s)

ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)

Batch: M103069

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 2.700" long

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

07/03/19

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK



Comment: SECOND CHECK

D 01.03.20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHAN | GES | | | | |
|---------|------|------------------------|----------|-------|------------|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| * | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| Part No |): | PAR #: Fault Category: | NCR: Yes | No DQ | A: <u></u> | Date: <u>≤</u> | 1/03/23 |

| | | | | QA: N/0 | C Closed: | Date: _ | · | | | |
|------|-------------------|----------------------------------|--|---|--|---|--|--|--|--|
| | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
| | Description of NC | | Corrective Action Section B | | Varification | | | | | |
| STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspecto | | | |
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| | STEP | STED Description of NC | STEP Description of NC Section A Initial | STEP Description of NC Section A Initial Action Description | WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Sign & | WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Section C Section C | STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng | | | |

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:32:49 PM User: Kim Johnston **Process Sheet Drawing Name: LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 31231 Part Number: D2591 Job Number: Seq. #: **Machine Or Operation:** Description: PACKAGING 1 6.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 7.0 Comment: FINAL INSPECTION/W/O RELEASE a 07.03.22 Job Completion

Dart Aerospace Ltd

| W/O: | | WORK ORDER CH | WORK ORDER CHANGES | | | | | | | |
|-----------|---|------------------------|--------------------|-------|-----|-------------------------------------|--------------------------|--|--|--|
| DATE STEP | | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| 2 | | | | | | | 1 | | | |
| Part No | : | PAR #: Fault Category: | NCR: Yes | No DQ | A: | Date: | | | | |

| Part No: | PAR #: Fault Category: | _ NCR: Yes No DQA: | Date: |
|----------|------------------------|--------------------|-------|
| | | QA: N/C Closed: | Date: |
| NCR: | WORK ORDER NON-CONFORM | ANCE (NCR) | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCK) | | | | | | | | |
|------|------|----------------------------------|----------------------|------------------------------|----------------|--------------|-----------------------|--------------------------|--|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Annroval | | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector | | |
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NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 31231 |
|------------------------------|--------------|-------------|
| Description: GHW Lug | Part Number: | D2591 |
| Inspection Dwg: D2591 Rev: D | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | | Prototype |
|---|---------------|--|-----------|
|---|---------------|--|-----------|

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| 1.20 | +/-0.030 | 1.201 | 1 | | | |
| Ø0.510 | +/-0.010 | .510 | | | | |
| 0.125 | +/-0.010 | 126 | | | | |
| 2.44 | +/-0.030 | 2.445 | 1 | | | |
| 0.65 | +/-0.030 | .652 | | | | |
| 0.50 | +/-0.030 | .501 | / | | | |
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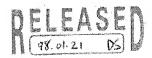
| Measured by: | Audited by: | Prototype Approval: | N/A |
|----------------|----------------|---------------------|-----|
| Date: 07/03/18 | Date: 07/03/18 | Date: | N/A |

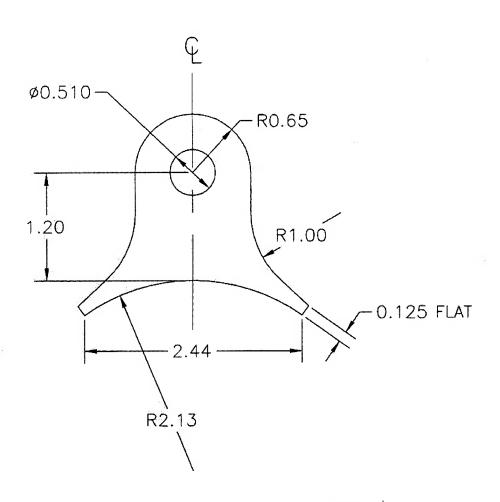
| Rev | Date | Change | | Revised by | Approx/ed |
|-----|----------|-----------|---------------------------------|------------|-----------|
| Α | 04.08.12 | New Issue | P/O D205-641-011 & DSI 9161-011 | KJ/JLM | |





| | and the second s | |
|----------|--|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED | APPROVED | DRAWING NO. REV. D |
| KE | Ew3 | D2591 SHEET 1 OF |
| DATE | <u>,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,</u> | TITLE SCALE |
| 98.01.21 | | GHW LUG 1: |
| A | 96:09:16 | NEW ISSUE |
| В | 97:06:17 | RE-DESIGN TO FLAT BOTTOM |
| С | 97.12.12 | RE-DESIGN TO RADIUS BOTTOM |
| | 98.01.21 | 0.125 FLAT WAS 0.067 FLAT |





0.063

BREAK ALL SHARP CORNERS 0.010 TO 0.020 MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE ON THE COPY PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING

SUBJECT TO AMENDMENT WITHOUT NOTICE